Ship Friday 11/07

Rev B 7/16/14

Work Order ID 121992

July-09-14 8:36:23 AM

121992 ~~PRELIMINARY ISSUE~~ POSITIVE RECALL

Item ID: D3870-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Mount, Fwd Upper

Start Date: 7/09/14 **Start Qty:** 12.00 *12*

Required Date: 7/09/14 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-09-09 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3870	**Revision Nbr** ~~PB1~~ Rev B DAS 27 8-89 14-7-16								
100	FLOW WATER JET	0.00							DAS 23 8-89 14-07-9
100 Waterjet	**Memo**	0.00				12	0		
FLOW CNC Waterjet 6061 .250"	1-Cut as per Dwg D3870 Dwg Rev: PB1 Prog Rev: PB1								
	— 2- OPEN HOLE TO SIZE AS PER DWG Deburr edges and holes if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 8-89 14-07-9
110 QC	**Memo**	0.00				12	0		
Quality Control									

DQA: _____ Date: _____

QA Closed: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

PRELIMINARY ISSUE

Work Order ID 121992 *121992*

July-09-14 8:36:23 AM

Item ID: D3870-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Mount, Fwd Upper

Start Date: 7/09/14 **Start Qty:** 12.00 *12*

Required Date: 7/09/14 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				12			
120									
QC	**Memo**	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00				12			
130									
HandFinish	**Memo**	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00				12			
140									
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89

DAS 27 9-89

DAS 30 9-89

POSITIVE RECALL

POSITIVE RECALL

EFFECTIVE MLJ AUTH 14-07-09

RELEASED 5 DATE 14/07/16

121. Form AS per Dwg.

122 QC5.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
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☐ Cut Too Short
☐ Drawing
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3870-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Mount, Fwd Upper

Start Date: 7/09/14 **Start Qty:** 12.00 *12*
Required Date: 7/09/14 **Req'd Qty:** 12.00 *12*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location:_____	0.00							
150									
Packaging	**Memo**	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLJ 14-07-16

14-7-10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

July-09-14 8:36:26 AM

PRELIMINARY ISSUE

Work Order ID: 121992 *121992*

Parent Item: D3870-5 *D3870-5*

Parent Item Name: Mount, Fwd Upper

Start Date: 7/09/14 **Required Date:** 7/09/14

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.000		Purchased	No			100	f	13.5000	0.2	3			

M6061T6B0.250X04.000

6061-T6 Bar .250 x 4.00

**

DAS 23 9-89

14-07-9

Location	Loc Qty	Loc Code	
MAT051	13.5		
124443	2.5		
m127464	11		27464

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

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Landing Gear

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	121992
Description: Mount	Part Number:	D3870-5
Inspection Dwg: D3870 Rev: PB1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257"	+0.006 -0.001	0.259"	–		V	Jkm01
0.500"	+/- 0.010"	0.503"	–		V	
0.250"	"	0.252"	–		V	
1.75"	+/- 0.030"	1.754"	–		V	
4.66"	"	4.66"	–		V	
1.00"	"	1.002"	–		V	

Measured by:	DAS 23 ~~8 89~~
Date:	14-07-9

Audited by:	DAS 27
Date:	14/9/10

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

PRELIMINARY ISSUE

10.04.15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

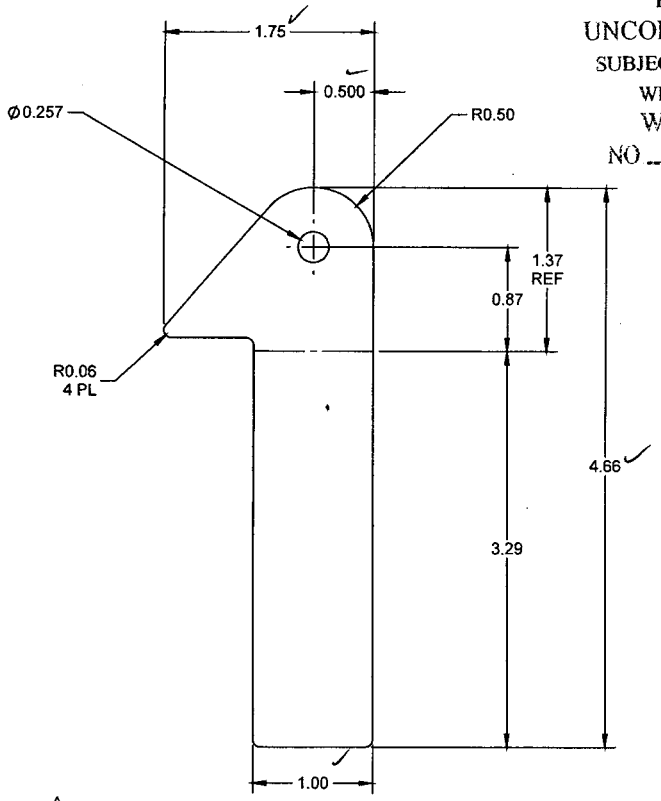
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

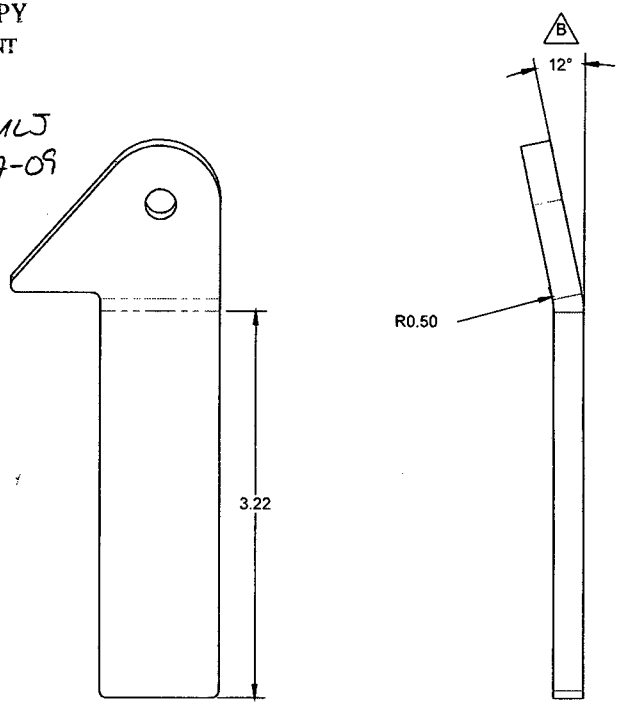
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 121992 MW
14-07-09



B D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



B D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
B 7) WEIGHT: 0.12 lbs

PRELIMINARY ISSUE

DB 14.07.04

DESIGN	HS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	DB	
CHECKED	ML	DRAWING NO. D3870 REV. B
MFG. APPR.	JLM	SHEET 5 OF 5
APPROVED	MP	TITLE MOUNT SCALE NTS
DE APPR.		
DATE	14.07.04	

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PRELIMINARY ISSUE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Receiving Report

Date: 13/11/13

Batch No: M/S 1469

Supplier: Inyssenth

Dart P/O: 21990

Packing Slip: Yes ✓ No

Invoice: Yes ___ No ✓

Receipt: Cash ___ Cr ✓

Release Note Attached: Yes ✓ No ___ N/A ___

Waybill Attached: Yes ___ No ✓

Shipment Complete: Yes ___ No ✓ N/A ___

QC6 Inspection ✓ BK 13/11/13 N/A ___

Work Order ___ N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: Date Received/Costing Initial 13/11/13 ✓

Location ___

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

B I L L O F L A D I N G

No: PEC 849931

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

Ship Date 12Nov13 at 13:23 From PFW
Probill
Via VIM TRANSFER
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

==========

B I L L O F L A D I N G

1) Our Order PEC-623889- 1 Your PO # 21995
ALUMINUM FLAT BAR 6061-T6511
.250" x 4.00" X 144.0000"
MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
2BU347	234791	12 FT	1	13

2) Our Order PEC-623889- 2 Your PO # 21995
ALUMINUM FLAT BAR 6061-T6511
.50" x 2.00" X 144.0000"
MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
Z00264054	234792	12 FT	1	14

3) Our Order PEC-623889- 3 Your PO # 21995
ALUMINUM FLT BAR ECONOPLT 6061-T6511
.500" X 10.00" X 144.0000"
MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
Z00191031	234793	48 FT	4	287

4) Our Order PEC-623889- 4 Your PO # 21995
ALUMINUM PLATE 6061-T651
2.750" THICK X 3.7500" X 96.0000"
MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
S12040359	234974	2.50 SFT	1	100

5) Our Order PEC-623889- 5 Your PO # 21995
ALUMINUM SHEET 6061 T6
.1250 Nom X 48.0000" X 96.0000"
MTR

Heat Number	Tag No	Quantity	PCS	Wt LBS
33566/01/00	234892	96.00 SFT	3	168

Page: 1 Continued

13/11/13 1 planche R506 1 palette R117 2 planches R559 1 planche R553 1 planche R506

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ETRE RAPPORTEES IMMEDIATEMENT
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

THYSSENKRUPP MATERIALS NA

DART AEROSPACE
ALUMINUM FLAT BAR 6061-T6511
.250" x 4.00" X 144.0000"
PART NO.

PO/Rel 21995

We certify that this is a true copy of the report furnished by the producer of the metal, or data resulting from tests made in approved labs.

Signed by:_____

Certificate of Mill Test Results

BL PEC-849931-001 12Nov13

EXTRUDEX ALUMINUM

TEL: (416)745-4444 FAX:(416)745-0925 1-800-668-7210
411 CHRISLEA ROAD, WOODBRIDGE, ONTARIO, CANADA L4L 8N4
http://www.extrudex.com

MILL TEST ASTM B221-12

BILL TO	Cert Code:	DIE NUMBER	DATE OF SHIPMENT	EXTRUDEX ORDER NO.	MANIFEST NO.
THYSSENKRUPP MATERIALS,NA	1 0.76	S 2215	8/6/2013	159754 — 1	292362
SHIP TO	CUSTOMER PO	ALLOY / TEMPER	SALESMAN	MADE IN CANADA	
THYSSENKRUPP MATERIALS,NA	PEC-250219	6061 T6511	FORBES DODWELL		
SO DESCRIPTION	CUSTOMER PART NUMBER	PART DESCRIPTION		CERTIFICATION	
.250"x4" FB	1-250-4000			MILL TEST ASTM B221-12	

Mechanical Properties

Lot	Alloy	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation	Hardness	Conductivity
A.11	6061	Jul/26/13	44.4	41.5	14.50	90.6, 91.2, 90.9	

Chemical Composition

	Cast Number	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Ga	V	B	Zr	Bi	Pb	Sn	Sr	Co	Al	Other
A.11	[redacted]2BU347 6061	0.63	0.15	0.22	0.03	0.90	0.07	0.00	0.01	0.01	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	Remainder	0.02

We certify that the following extrusions have been quality inspected/tested and conforms to required dimensional and temper specifications.

David Natale
Quality Control Manager

1 - CUSTOMER COPY

Doc No. 164466 Indexed 7Aug13 by slssup1

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO21995

Purchase Order Date 11/8/2013
PO Print Date 11/8/2013

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905 669 9444
Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

3	M6061T6B0.250X04.000	6061-T6 Bar .250 x 4.00	11/15/2013 Yes 11/15/2013	12.00 f			$2.50	$30.00
	MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS-A/200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221							
						Line Total:		**$30.00**
4	M6061T6B0.500X02.000	6061-T6 Bar .500 x 2.00	11/15/2013 Yes 11/15/2013	12.00 f			$2.50	$30.00
	SAME AS ABOVE							
						Line Total:		**$30.00**
5	M6061T6B0.500X10.000	6061-T6 Bar .500 x 10.00	11/15/2013 Yes 11/15/2013	48.00 f			$11.16	$535.80
	SAME AS ABOVE							
						Line Total:		**$535.80**

PO Instructions: NO: PEC ST-621584
NO: PEC ST-621370

Note:

DART AEROSPACE LTD

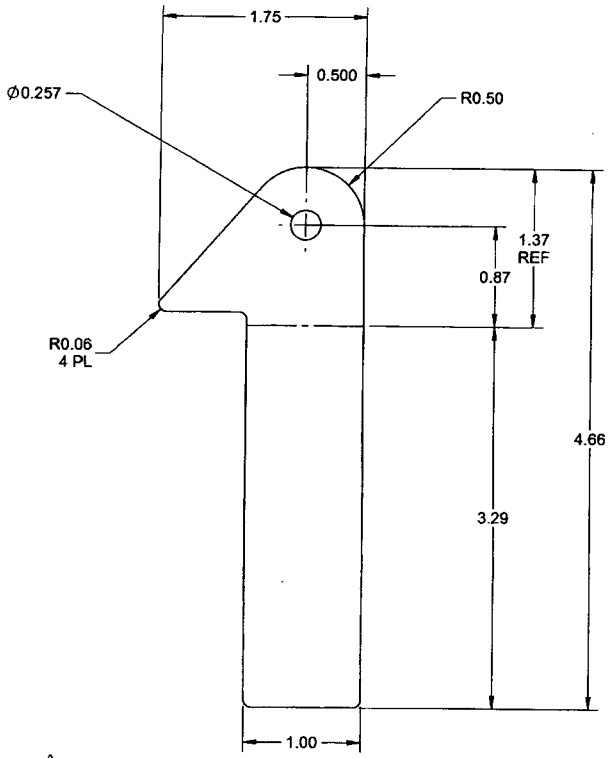
Description: Mount, Fwd Upper Work Order: 121992

Inspection Drawing: D3870 Rev: BB1 Part Number: D3870-5

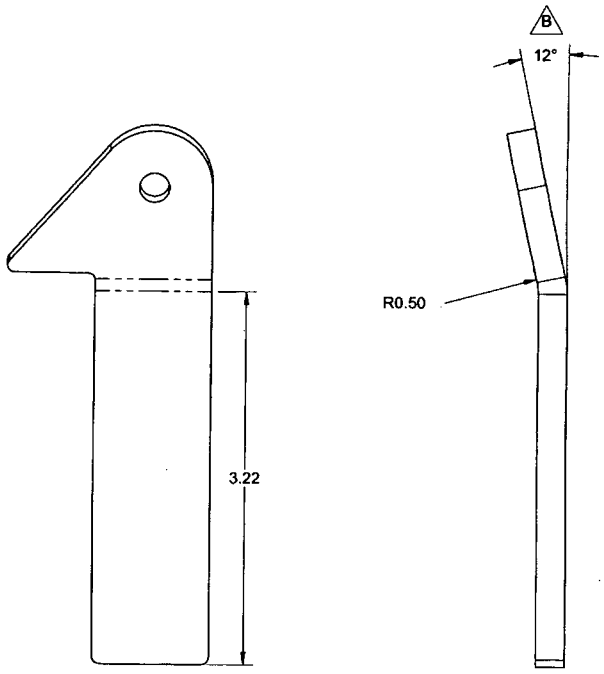
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.22	+/- .030	3.22	✓		V	SS-11
12°	+/- 1/2°	12°	✓		Angle protractor	SS-7

Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: AS 27 9-89	Engineering Approval (*if necessary*)
Date 14/07/10	Date 14/07/10	Date 14/7/10	Date



B D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



B D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F

RELEASED
2014 -07- 15

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
B 7) WEIGHT: 0.12 lbs

APPROVED

DESIGN	HS	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	ML	DRAWING NO. D3870 REV. B
MFG. APPR.	JLM	SHEET 5 OF 5
APPROVED	MP	TITLE MOUNT SCALE NTS
DE APPR.	DS	
DATE	14.07.04	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

